

54534. Deriv.

SPLIT-2.

Work Order ID 52402-2

September 22, 2009 11:33:06 AM

Page 1

Item ID: D3849-043

Revision ID: B

Item Name: AFT WEARPLATE ASSY, STD GEAR

Start Date: 09/23/2009 Start Qty: 2.00

Required Date: 10/02/2009 Req'd Qty: 2.00

Reference:

Accept

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan: MF

Date: 09-09-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3849

B

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3849

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

IB 9-9-30

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

IB 9-9-30

246

(Photo) →

(7)

Work Order ID 52402

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Page 2

Item ID: D3849-043
 Revision ID: B
 Item Name: AFT WEARPLATE ASSY, STD GEAR
 Start Date: 09/23/2009 Start Qty: 2.00
 Required Date: 10/02/2009 Req'd Qty: 2.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	280210101			(+7)	7		
130 Brake NC Brake NC	Memo Form as per dwg using DT8179 & DT8155	0.00 0.00	28 09/00/05			7	0		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	280210102			(+7)	1		

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Page 3



Accept



Setup Start



Revision ID: B

Stop



Item Name: AFT WEARPLATE ASSY, STD GEAR

Start Date: 09/23/2009 **Start Qty:** 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamp

150



Large Fab

Large Fab

Memo

0.00

1- On D3901 bar, fill cut outs with hardcoat welding rod as per dwg D3849

2059 B Hardcoat Welding Rod

BATCH#: m117963

2- Weld D3901 bar to wearplate by positioning holes together as per dwg D3849

304 S.S. Welding Rod

BATCH #: M107421

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

$$I_x$$

6/07/12/03

Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 4

Item ID: D3849-043
Revision ID: B
Item Name: AFT WEARPLATE ASSY, STD GEAR

Accept



Setup Start



Stop



Start Date: 09/23/2009 Start Qty: 2.00
Required Date: 10/02/2009 Req'd Qty: 2.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(X)			
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 1:45pm OVEN TEMPERATURE: 320°f FINISH TIME: 2:15pm	0.00 0.00				(X)			
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(1)			

=> 809/12/03

=> 11 09/12/03

80 09/12/04

Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 5

Item ID: D3849-043

Revision ID: B

Item Name: AFT WEARPLATE ASSY, STD GEAR

Start Date: 09/23/2009 Start Qty: 2.00

Required Date: 10/02/2009 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Small Fab

Small Fab

Memo

1- Bond D3848 gasket to inner surface of wearplate using a thin layer of 3m
1300/1300L scotch grip adhesive as per dwg D3849
BATCH: M 11374

0.00

0.00

88 09/12/04

①

①

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 5 09/12/04

①

f

220



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

P. 11/12/04

Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 6

Item ID: D3849-043

Accept



Setup Start



Revision ID: B

Item Name: AFT WEARPLATE ASSY, STD GEAR

Stop



Start Date: 09/23/2009 Start Qty: 2.00



Required Date: 10/02/2009 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/11 *[Signature]*
MF 09-12-11

Picklist Print

Page 1

September 22, 2009 11:33:05 AM

Work Order ID: 52402



Parent Item: D3849-043RevB



Parent Item Name: AFT WEARPLATE ASSY, STD GEAR

Start Date: 09/23/2009

Required Date: 10/02/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3848-3RevB 		Manufactured	No				Each	0.0000	2.0000			
Gasket D3901-3RevB 		Manufactured	No				Each	0.0000	2.0000			
Bar M304S18GA 		Purchased	No				sf	183.4395	6.4211			
304/316 .050 Sheet												

85 09/12/04

853053 + 1

12 9-12-3 (21)

27.4738

189-9-30

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	183.4395053	
108156	0.98526316	
111743	23.7174	
112178	158.736842	

112178

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø	375	+0.06 - 0.01	377	*			
	125	± 0.10	128	*			
	88	± 0.30	88.0	*			
	75	± 0.30	75.2	*			
	2.45	± 0.30	2.45	*			
	4.38	± 0.30	4.384	*			
	7.00	± 0.30	7.005	*			
	51.000	± 0.10	51.000	*			
	66.87	± 0.30	66.875	*	73.500"		
Ø	185	+0.05 - 0.01	192	*			
	2.433	± 0.10	2.430	*			
	6.642	± 0.10	6.639	*			
	18.712	± 0.10	18.712	*			
	36.629	± 0.10	36.629	*			
	62.799	± 0.10	62.799	*			
	4.00	± 0.30	4.007	*			
	7.72	± 0.30	7.709	*			
	1050	± 0.10	1050	*			
				</			

Measured by:		Audited by:		Prototype Approval:	
Date:		Date:		Date:	
Rev		Date		Revised by	
A		Change		Approved	
		New Issue		KJ/JLM	

8

7

6

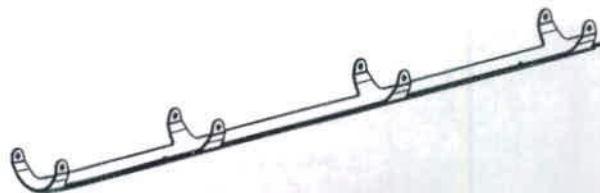
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4

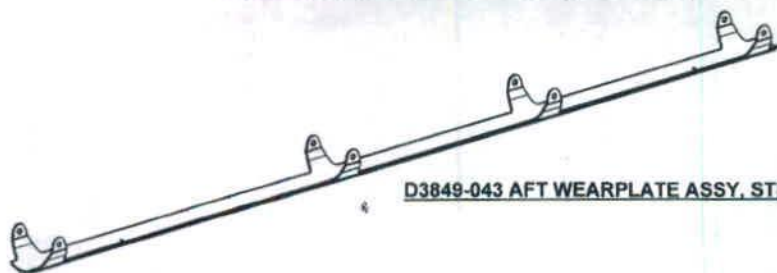
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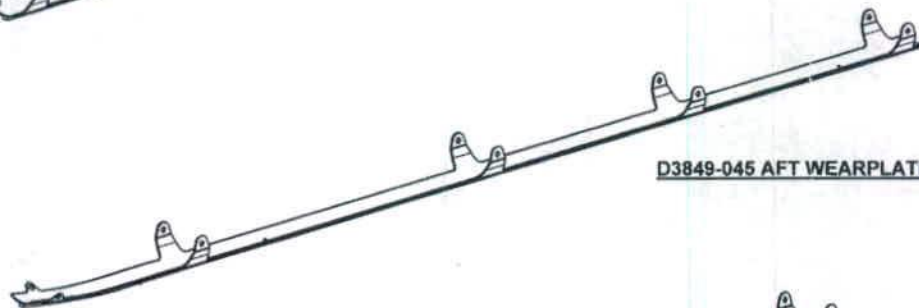
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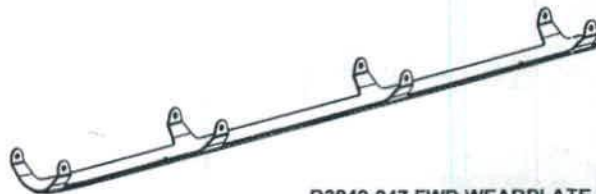
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1				D3848-1	GASKET
16		1			D3848-3	GASKET
17			1		D3848-5	GASKET
18				1	D3848-7	GASKET
19	1			1	D3901-1	BAR
20		1			D3901-3	BAR
21			1		D3901-5	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

452402

RELEASED
9/27/15

B	REVISED FLAT PATTERN (0.375 WAS SLOT HOLE ON D3849-17-35-16F (ZN A4-5, B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7-7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.14 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C8-2, C3-2, A8-3, C8-3, C3-3, A8-4, C6-4, C2-4); 66.87 WAS 67.36 (ZN S4-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3849	SHEET 1 OF 10
APPROVED	AM	TITLE	SCALE
DE APPR.	PH	WEARPLATE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8

7

6

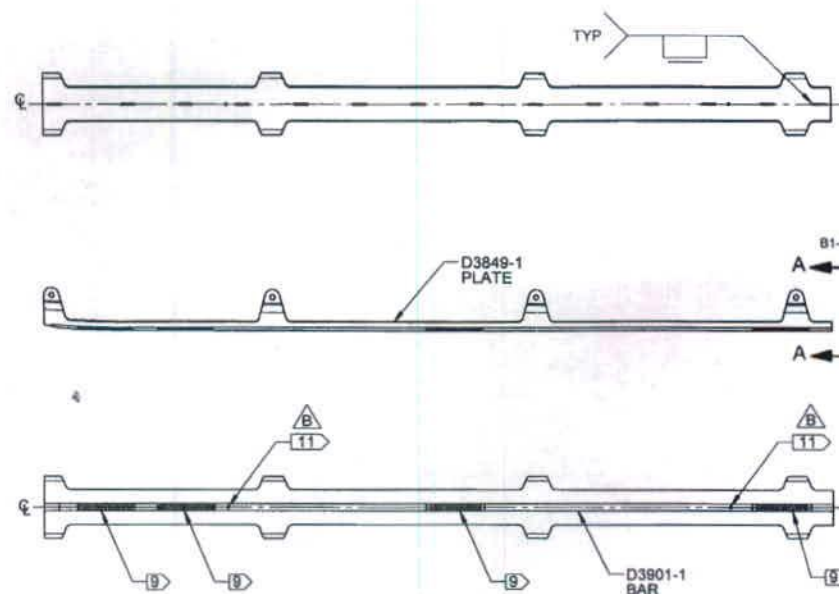
5

4

3

2

1



D3849-041 FWD WEARPLATE ASSY. STD/FLOAT GEAR



SECTION A-A C3-2
SCALE 2X

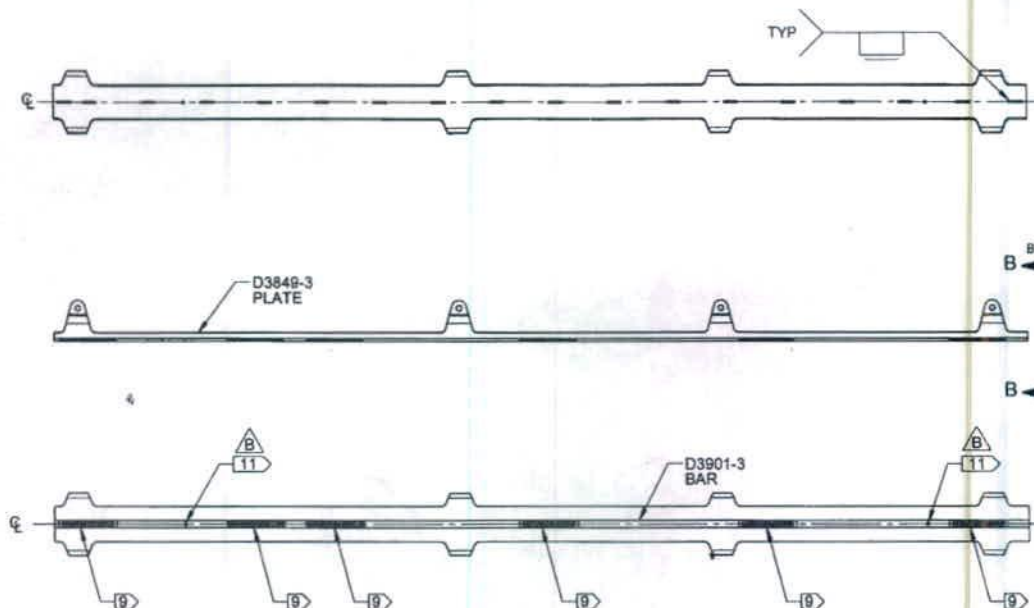
RELEASED
12/27/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-041" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-041 = 4.24 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-1 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-1 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, VA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 2 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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D3849-043 AFT WEARPLATE ASSY, STD GEAR

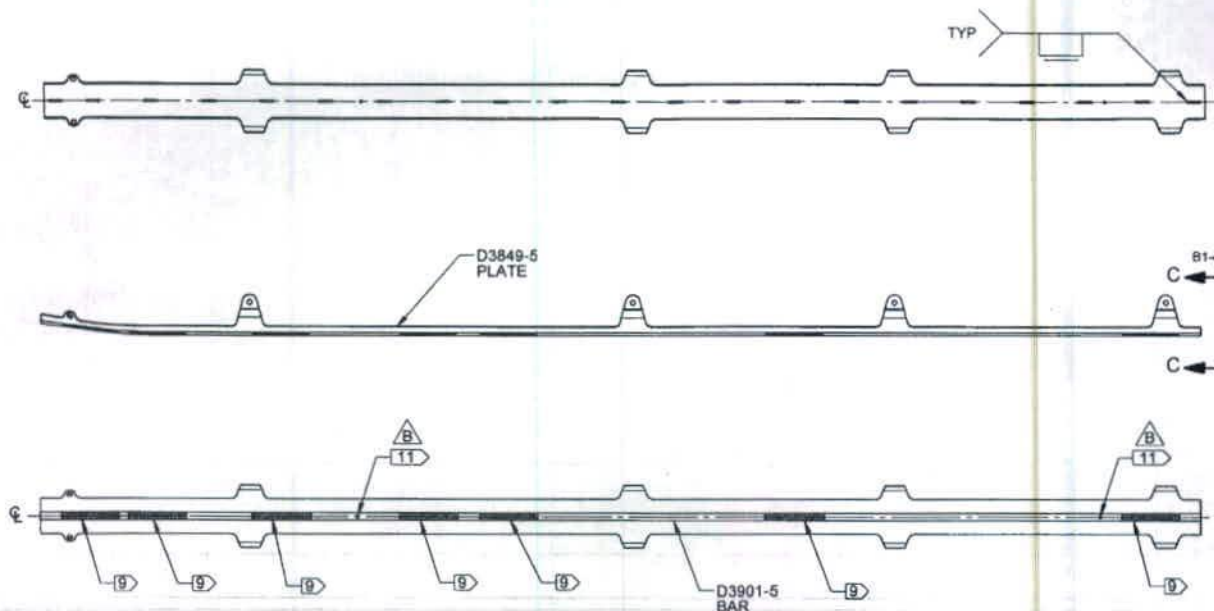
SECTION B-B C2-3
SCALE 2X

RELEASED
10/27/15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3849-043 = 5.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\phi 0.188$ HOLES FROM D3849-3 PLATE TO D3901-3 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 3 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



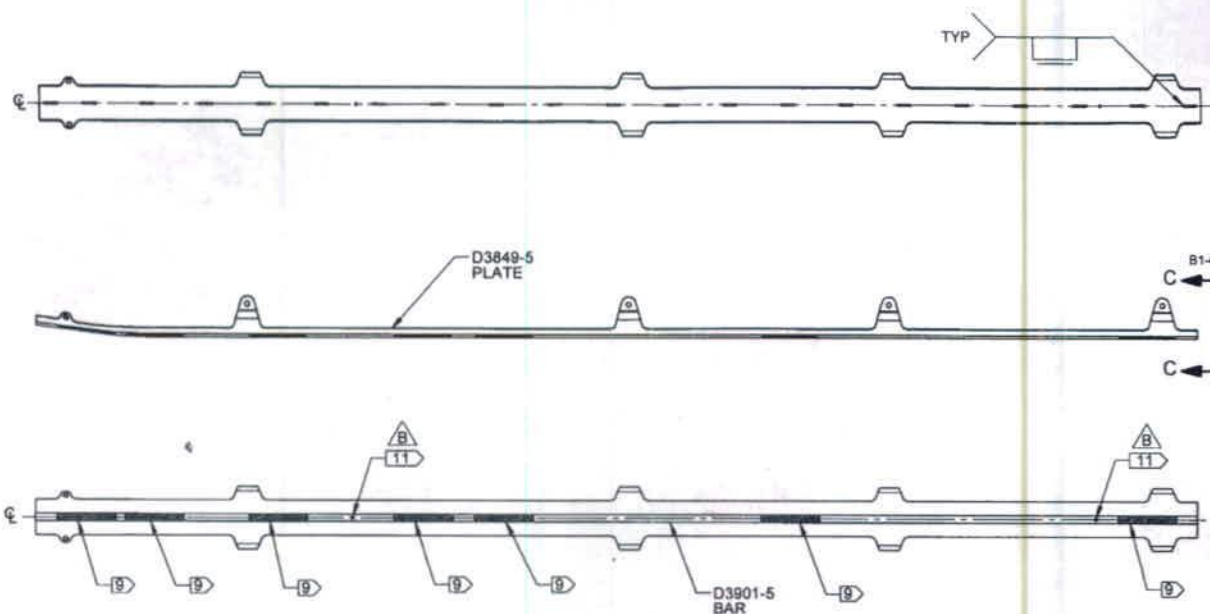
SECTION C-C C2-4
SCALE 2X

RELEASED
09/06/30

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 5.98 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-5 PLATE TO D3901-5 BAR

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3849	REV. B
MFG. APPR.	RF	SHEET 4 OF 10	
APPROVED	RF	TITLE WEARPLATE ASSY	SCALE NTS
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D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



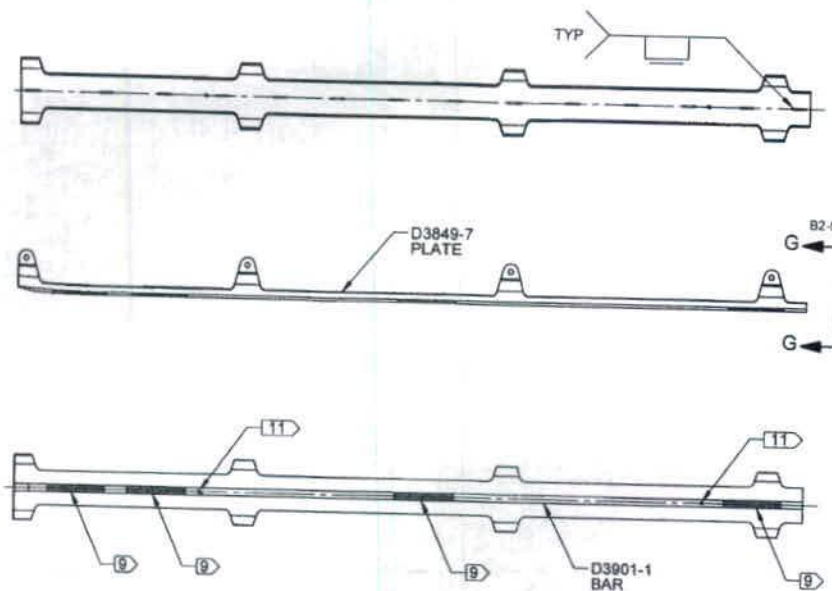
SECTION C-C C2-4
SCALE 2X

RELEASED
09/15/14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 5.98 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-5 PLATE TO D3901-5 BAR

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3849	REV. B
MFG. APPR.	RF		SHEET 4 OF 10
APPROVED	RF	TITLE WEARPLATE ASSY	SCALE NTS
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DATE	09.06.30		



D3849-047 FWD WEARPLATE ASSY. FLOAT GEAR

#52402



SECTION G-G C3-5
SCALE 2X

RELEASED
09/07/15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-047" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-047 = 4.26 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-7 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-7 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 5 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2025 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

0.3 REF

R38.5

49.51

D3849-1 PLATE
(MAKE FROM D3849-1F)

A6-10

#52402

0.050
REF

7.72

51.313

36.000

DETAIL G

R0.38
TYP

DETAIL F

18.000

DETAIL H

2.45

2.433
TYP6.642
4 PLØ0.188 THRU
2 PL105°
TYPR0.50
TYP4.00
TYP

4.38

R0.06
2 PL

34.500

54.26 REF

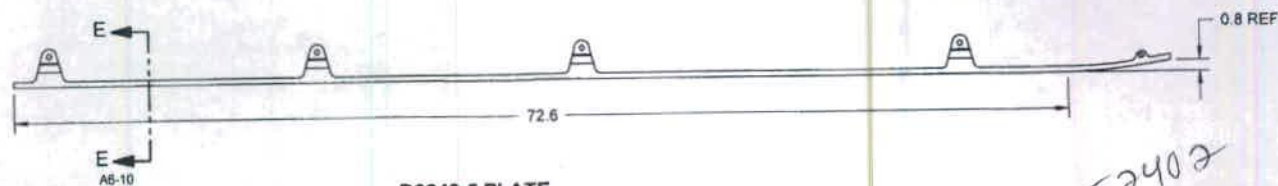
D3849-1F FLAT PATTERN

RELEASED
09/06/2009

NOTES:

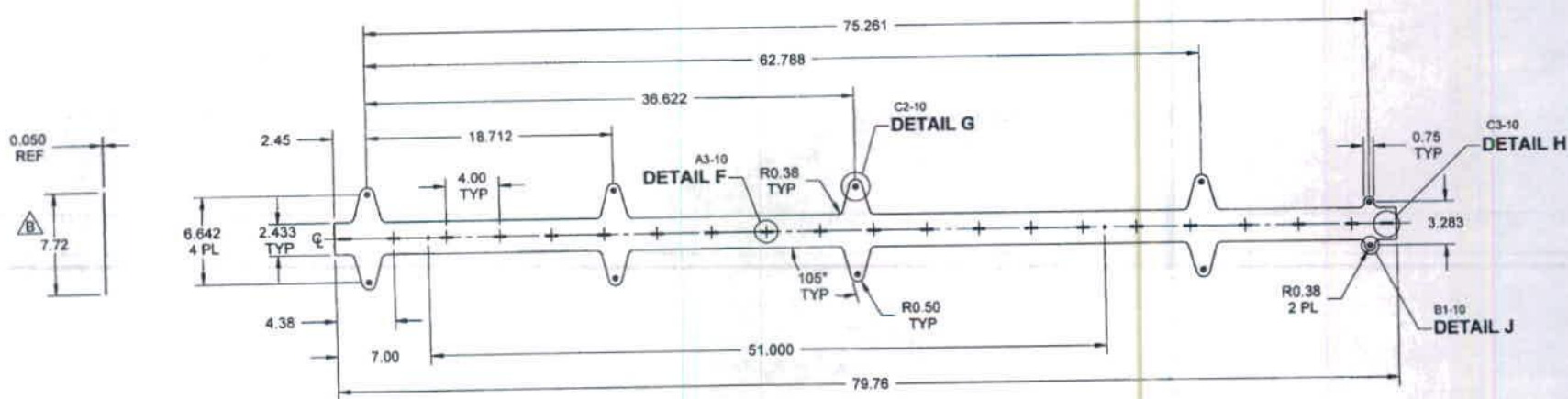
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 6 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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D3849-5 PLATE
(MAKE FROM D3849-5F)

#52402



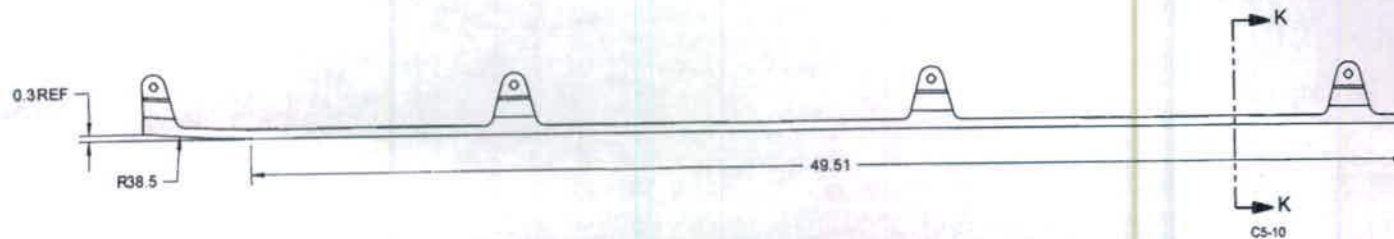
D3849-5F FLAT PATTERN

RELEASED
9/10/54

NOTES:

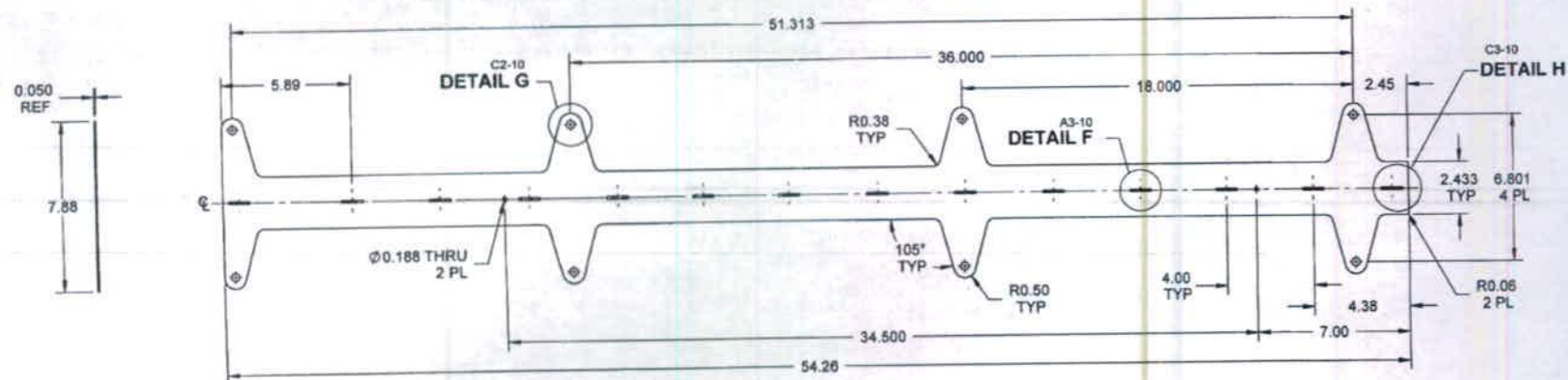
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.30 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
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D3849-7 PLATE
(MAKE FROM D3849-7F)

#52402



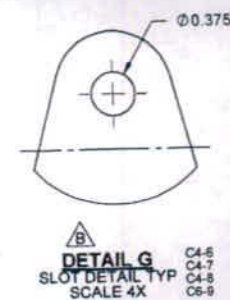
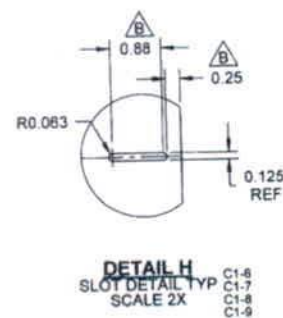
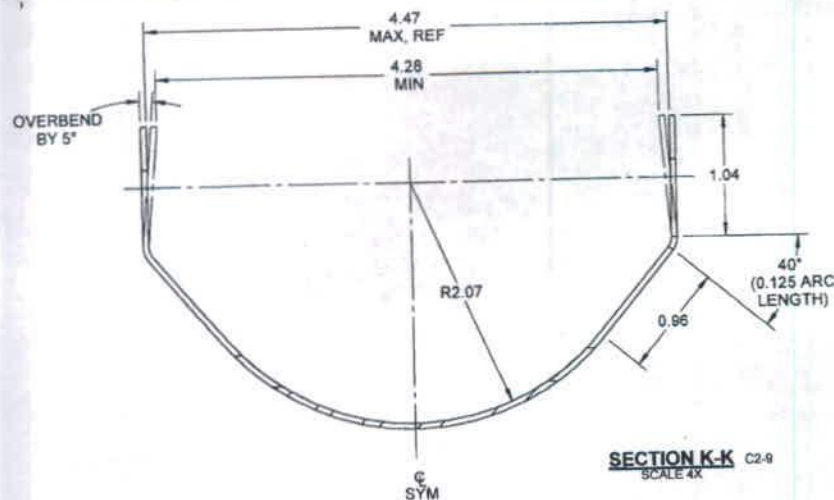
D3849-7F FLAT PATTERN

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09/07/15

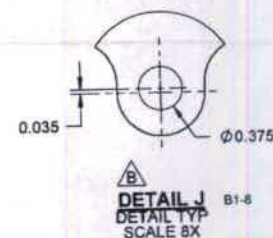
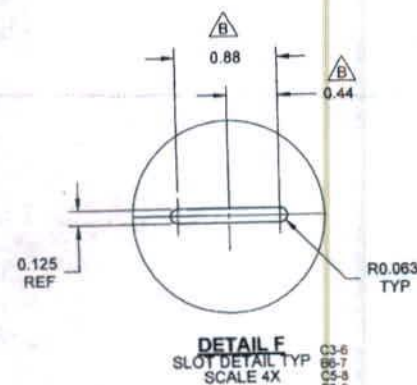
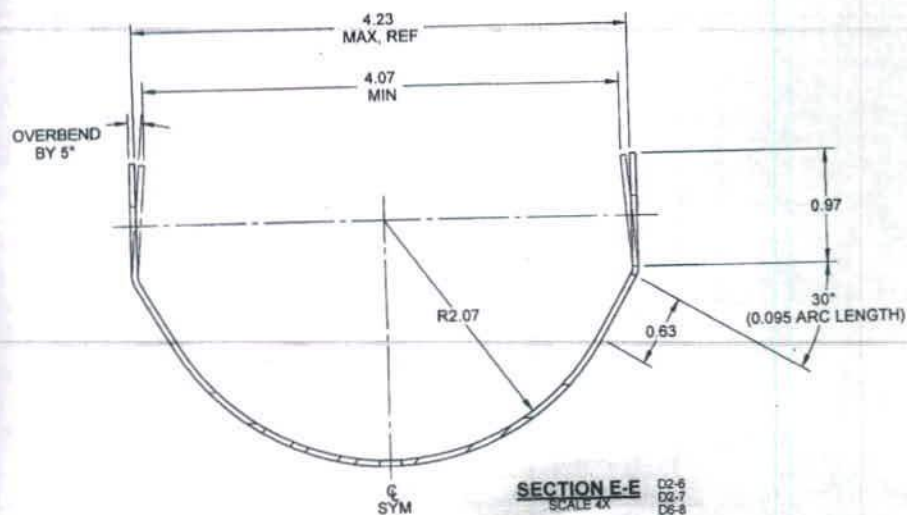
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.34 lbs

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